

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022718**Date Inspected:** 09-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020U

Weld No: 591

Welder: 067572, 066002, 067609, 067904

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: SEG3020R

Weld No: 087,125

Welder: 066398, 067611

Weld Repair No. B-CWR2912

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WPS-345-SMAW-3G(3F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG Traveler Rails

PCMK: TR3021TR1-001

Weld No: 001~004

Welder: 066734, 201215

WPS-B-T-2232-ESAB

Components; OBG Traveler Rails

PCMK: TR3021TR3-001

Weld No: 001~004

Welder: 066734, 201215

WPS-B-T-2232-ESAB

Components; OBG 14W

PCMK: SEG3020A

Weld No: 013,021

Welder: 201583, 045143

WPS-B-T-2232-ESAB

Components; OBG 14W

PCMK: SEG3020N

Weld No: 069

Welder: 067876

WPS-B-T-2232-ESAB

Heat straightening of PCMK TR3002TR1-001-002,004,006,007,008,010,011 under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 350°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Heat straightening of PCMK TR3002TR2-001-002,004,006,007,008,010,011 under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 390°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

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Heat straightening of PCMK TR3008TR1-001-002,004,006,007,008,010,011 under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 470°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Heat straightening of PCMK TR3008TR2-001-002,004,006,007,008,010,011 under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 420°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
